



Dart Aerospace Ltd.
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D3571-1**Job Sheet 194651****Part No:** D3571-1**Job Qty:** 8 pcs**Part Name:** Guide**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 5/7/19**Job Tracking No:****Due Date:** 5/27/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV A IPP Rev:A New Issue 07-02-01 JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	8 pcs	5/27/19	5/27/19	0.00	0.15	Bandsaw - 1		DJP 19-05-15
110	HAAS 4 Axis - B4B	8 pcs	5/27/19	5/27/19	0.40	5.41	HAAS - 1 - B4B		DJP 19-05-15
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	8 pcs	5/27/19	5/27/19	0.00	0.00	QC 2 - 1		DJP 19-05-15
							QC 2 - 2		
							QC 2 - 3		
							QC 2 - 4		
							QC 2 - 5		
							QC 2 - 6		
							QC 2 - 7		
							QC 2 - 8		
							QC 2 - 9		
							QC 2 - 10		
							QC 2 - 11		
							QC 2 - 12		
							QC 2 - 13		
							QC 2 - 14		
							QC 2 - 15		
							QC 2 - 16		
							QC 2 - 17		
							QC 2 - 18		
							QC 2 - 19		
							QC 2 - 20		
							QC 2 - 21		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 24		
							QC 2 - 25		
							QC 2 - 26		
							QC 2 - 27		
							QC 2 - 28		
							QC 2 - 29		
							QC 2 - 30		
							QC 2 - 31		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 34		
							QC 2 - 35		
							QC 2 - 36		
							QC 2 - 37		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 40		
							QC 2 - 41		
							QC 2 - 42		
							QC 2 - 43		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 46		
							QC 2 - 47		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 53		
							QC 2 - 54		
							QC 2 - 55		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 58		
							QC 2 - 59		
							QC 2 - 60		
							QC 2 - 61		
							QC 2 - 62		

**Container No:** S181740**Part:** D3571-1**Job No:** 194651**Serial No/Batch:** S181740**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

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Date: 05/15/19

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130 QC 8	8 pcs	5/27/19	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	mk 19/05/22
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
140 Handfinish - 1-1 Chemical- B4B	8 pcs	5/27/19	0.00 0.23	Handfinish - 1 - 1 - B4B	MAY 22 2019
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 -	

				B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 3 Grey Sand - B4B	8 pcs	5/27/19	0.00 0.16	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				QC 3 - 10	
160 QC 3	8 pcs	5/27/19	0.00 0.00	QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
170 Packaging 3-1 - Stock - B4B	8 pcs	5/27/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	

				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	8 pcs	5/27/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-09 MAY 24 2019

Part Op 100 - Cut blank 2.90 " long

Descriptions: 110 - (HAAS CNC Vertical Machine), 1- Mill as per Folio FA675Rev: _____ & Dwg D3571 Rev: _____ 2-Deburr per dwg D3571

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3), START TIME: _____

160 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location:_____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X01.500	6061-T6 Bar .750 X 1.50	1.9280 ft (.241 ea)	100-Bandsaw - 1	5168972

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.750X01.500	2	113	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hook	5.4500inches ± 0.0300	5.4800 5.4200		
2	Hook	0.2500inches ± 0.0300	0.2800 0.2200	Radius	
3	Hook	0.2800inches ± 0.0300	0.3100 0.2500	Radius	
4	Hook	30.0000inches ± 0.5000	30.5000 29.5000	Degrees	
5	Hook	0.3900inches ± 0.0300	0.4200 0.3600	Radius	
6	Hook	10.0000inches ± 0.5000	10.5000 9.5000	Degrees	
7	Hook	0.2800inches ± 0.0300	0.3100 0.2500	Radius	
8	Hook	34.0000inches ± 0.5000	34.5000 33.5000	Degrees	
9	Hook	0.3900inches ± 0.0300	0.4200 0.3600		
10	Hook	0.8600inches ± 0.0300	0.8900 0.8300		
11	Hook	0.2000inches ± 0.0100	0.2100 0.1900		
12	Hook	2.2900inches ± 0.0300	2.3200 2.2600		
13	Hook	0.1600inches ± 0.0300	0.1900 0.1300		
14	Hook	70.0000inches ± 0.5000	70.5000 69.5000	Degrees	
15	Hook	40.0000inches ± 0.0300	40.0300 39.9700		
16	Hook	2.6100inches ± 0.0300	2.6400		

MAT
used
1.966'
-1.928
0.038
Scrap

			2.5800	
17	Hook	0.1740inches $\pm$ 0.0100	0.1840 0.1640	
18	Hook	60.0000inches $\pm$ 0.5000	60.5000 59.5000	Degrees
19	Hook	0.2040inches + 0.0050 - 0.0010	0.2090 0.2030	Diameter
20	Hook	0.3740inches $\pm$ 0.0100	0.3840 0.3640	
21	Hook	0.7480inches $\pm$ 0.0100	0.7580 0.7380	
22	Hook	0.3500inches $\pm$ 0.0300	0.3800 0.3200	
23	Hook	0.7500inches $\pm$ 0.0050	0.7550 0.7450	
24	Hook	3.2500inches $\pm$ 0.0050	3.2550 3.2450	
25	Hook	0.5500inches $\pm$ 0.0100	0.5600 0.5400	
26	Hook	0.1300inches $\pm$ 0.0300	0.1600 0.1000	Radius
27	Hook	0.0200inches $\pm$ 0.0300	0.0500 (0.0100)	Radius
28	Hook	1.9700inches $\pm$ 0.0300	2.0000 1.9400	
29	Hook	2.4300inches $\pm$ 0.0300	2.4600 2.4000	
30	Hook	1.8700inches $\pm$ 0.0300	1.9000 1.8400	
31	Hook	0.0500inches + 0.0050 - 0.0010	0.0550 0.0490	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order:	
Description: Guide		Part Number:	D3571-1
Inspection Dwg: D3571 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	0.699	✓		Vern.	
Ø1.00 Depth 100	+/-0.010	0.997x.100	✓		Vern/D.G.	
2.75	+/-0.030	2.752	✓		Vern.	
1.38	+/-0.030	1.38	✓		Vern.	
1.25	+/-0.030	1.251	✓		Vern.	
0.63	+/-0.010	0.630	✓		Vern.	
0.031 chamfer	+/-0.010	0.030	✓		Vern.	
Ø0.500	+0.006/-0.001	0.502	✓		Vern.	
Ø0.201	+0.005/-0.001	0.201	✓		Vern.	
R0.25	+/-0.030	0.250	✓		R.G.	
0.260	+0.000/-0.010	0.254	✓		G.P.	
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	0.388x100°	✓		Vern.	
0.125	+/-0.010	0.125	✓		G.P.	
2.250	+/-0.010	2.252	✓		Vern.	
0.250	+/-0.010	0.259	✓		Vern.	
0.188	+/-0.010	0.188	✓		Vern.	
0.063 chamfer	+/-0.010	0.062	✓		Vern.	

Measured by: DJP	Audited by: [Signature]	Prototype Approval:	N/A
Date: 19-05-15	Date: 19/05/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM [Signature]	[Signature]